



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DLL-#F-B-#5
Job Sheet 177801



Part No: DLL-#F-B-#5

Job Qty: 4 ea

Part Name: Thimble Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/18/18

Job Tracking No:

Due Date: 5/18/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG DLL-#-#-# Rev. A IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Large Fab-7		EL
100	HandFinish	4 pcs	5/18/18	5/18/18	0.00	0.40	HandFinish7		DYC 18/05/18
110	Large Fab	4 pcs	5/18/18	5/18/18	0.00	8.00	Large Fab 3		DYC 18/05/18
115	QC	4 pcs	5/18/18	5/18/18	0.00	0.00	QC9		EL
120	QC	4 pcs	5/18/18	5/18/18	0.00	0.00	QC5		EL
130	SprayPaint	4 pcs	5/18/18	5/18/18	0.00	0.40	Spray Paint		BK 18-5-18
140	QC	4 pcs	5/18/18	5/18/18	0.00	0.00	QC14		14-18-5-18
180	Packaging	4 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3		
190	QC21-SA	4 Ea	5/18/18	5/18/18	0.00	0.00	QC21		med 18/05/18

Part Op 100 - 1-Bead blast, remove paint. 2-Paint on the inside of the thimble side tubes can remain.

Descriptions: 110 - 1-Weld as per DWG. 2-Grind as per DWG. 3-Remove factory markings. 4-Drill holes as per DWG. 5-Deburr.

130 - Prime and paint as per DWG. PRIME: Start Time: 10:20 Finish Time: 10:50 PAINT: Start Time: 10:50

Finish Time: 11:38/39

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
7750K233	Standard-Wall Steel Pipe, 1 Pipe Size, 5' Long	.5000 ft (.125 ea)	90-Start up Operation	9264033

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	7750K233	1	3	0

Part Specifications

Specifications could not be found.

Plex 5/18/18 10:30 AM dart.Lussier.Patrick

DART
AEROSPACE

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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S072622



Part: DLL-#-F-B-#-5

Job No: 177801

Serial No/Batch: S072622

Revision: A

Inspector:

Date: 05/18/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>177801</u> Part No. <u>DLL-F-B-#-5</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Description Work Order Deviation				Disposition																																																																											
- Thimble assembly has been powder coated black instead of Zinc plating or prime and paint.				This deviation is acceptable for this work order only. -No impact on fit, form or function.																																																																											
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								Lead hand / Supervisor Approval Verification																																																																							
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